



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3197-041
Job Sheet 191866-A

[Handwritten signature]
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Part No: D3197-041

Job Qty: 7 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/28/19

Job Tracking No:

Due Date: 4/10/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev: A New Issue 05-11-08 JLM IPP Rev:B As per Rev B 06-03-10 JLM

Ship Via:

5184783

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
170	QC 3	7 pcs	4/10/19	4/10/19	0.00	0.00	QC 3 - 10		58	
180	Small Fab - 2 - B4B	7 pcs	4/10/19	4/10/19	0.00	1.79	Small Fab - 1 - B4B		9-89	MAY 2 8 2019
							Small Fab - 2 - B4B			DAS
							Small Fab - 3 - B4B		58	
							Small Fab - 4 - B4B		9-89	
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
190	QC 5	7 pcs	4/10/19	4/10/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
200	Packaging 3-1 - Stock - B4B	7 pcs	4/10/19	4/10/19	0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			
							Packaging 3 - 5 - B4B			
							Packaging 3 - 6 - B4B			

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 54.255
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	7 pcs	4/10/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-65

MAY 29 2019

Part Op 170 - (QC3- Inspect Part Finish)
 Descriptions: 180 - (Small Fab) Assemble D3197-041 as per Dwg D3197
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2690-5	Lanyard Assembly	14 pcs (2 ea)	180-Small Fab - 2 - B4B	
D3242-1	Tag	14 pcs (2 ea)	180-Small Fab - 2 - B4B	
D3489-3-200	Pip Pin	14 pcs (2 ea)	180-Small Fab - 2 - B4B	
MS21042L3	Nut	14 Ea (2 ea)	180-Small Fab - 2 - B4B	
MS27039-1-24	Screw	14 Ea (2 ea)	180-Small Fab - 2 - B4B	
NAS1149D0363J	Washer	42 Ea (6 ea)	180-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
180-Small Fab - 2 - B4B	D2690-5	14	22	0
	D3242-1	14	18	0
	D3489-3-200	14	15	0
	MS21042L3	14	2,195	0
	MS27039-1-24	14	94	0
	NAS1149D0363J	42	1,558	0

Part Specifications
Specifications could not be found.

Plex 5/28/19 2:22 PM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

010030
Unit

D3197-041
Job Sheet 191866



Part No: D3197-041

Job Qty: 8 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev: A New Issue 05-11-08 JLM IPP Rev: B As per Rev B 06-03-10 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	4/10/19	4/10/19	0.00	0.70	Bandsaw - 1	DAS 52 9-89	19/05/25
110	HAAS 4 Axis - B4B	8 pcs	4/10/19	4/10/19	0.51	5.93	HAAS - 1 - B4B	DAS 52 9-89	19/05/25
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs	4/10/19	4/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS 52 9-89	19/03/25
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S184045



Part: D3197 - 041

Job No: 191866

Serial No/Batch: S184045

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/28/19

Plex 3/11/19 10:55 AM Dart.lajeunesse.marie

					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
130	Conventional Lathe - 1 - B4B	8 pcs	4/10/19	0.00 1.41	Conventional Lathe - 1 - B4B	DAS 52 19/05/25 9-89
					Conventional Lathe - 2 - B4B	
140	QC 8	8 pcs	4/10/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
150	Handfinish - 1-1 Chemical-B4B	8 pcs	4/10/19	0.00 0.69	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 3 Grey Sand-B4B	8 pcs	4/10/19	0.00 0.35	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
START: 8:55 A.T. 300 Finish 19:25 MIB8834						BL 19-05-21

170 QC 3	8 pcs	4/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	DAS
				QC 3 - 58	58 MAY 28 2019
				QC 3 - 59	9-89
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
180 Small Fab - 2 - B4B	8 pcs	4/10/19	0.00 2.05	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	58 MAY 28 2019
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
190 QC 5	8 pcs	4/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Packaging 3-1 - Stock - B4B	8 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	8	4/10/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: 29.125" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (Manufacture as per dwg) Chamfer as per Dwg D3197
 140 - (QC8- Inspect parts - second check)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Assemble D3197-041 as per Dwg D3197
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

5184045

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73R1.000	7075-T73 Round Bar 1.00	19.3600 ft (2.42 ea)	100-Bandsaw - 1	5168065
D2690-5	Lanyard Assembly	16 pcs (2 ea)	180-Small Fab - 2 - B4B	5184116
D3242-1	Tag	16 pcs (2 ea)	180-Small Fab - 2 - B4B	5167911x10
D3489-3-200	Pip Pin	16 pcs (2 ea)	180-Small Fab - 2 - B4B	5151275x3 5181852
MS21042L3	Nut	16 Ea (2 ea)	180-Small Fab - 2 - B4B	5166212
MS27039-1-24	Screw	16 Ea (2 ea)	180-Small Fab - 2 - B4B	5043817x6
NAS1149D0363J	Washer	48 Ea (6 ea)	180-Small Fab - 2 - B4B	5162884

MAT
used
19.45
x12
-0.09

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73R1.000	19	4	0
180-Small Fab - 2 - B4B	D2690-5	16	4	0
	D3242-1	16	8	0
	D3489-3-200	16	5	0
	MS21042L3	16	3,908	0
	MS27039-1-24	16	110	0
	NAS1149D0363J	48	963	0

Part Specifications	
Specifications could not be found.	

Plex 3/11/19 10:55 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	191866
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓		TAPE	
25.06	+/-0.030	25.06	✓		TAPE	
11.44	+/-0.030	11.44	✓		TAPE	
0.500	+/-0.010	0.501	✓		Ver	
0.250	+/-0.030	0.250	✓		Ver	
Ø0.219	+0.005/-0.000	0.219	✓		G.P.	
Ø0.191	+0.005/-0.000	0.191	✓		G.P.	
1.000	+/-0.005	0.999	✓		Ver	
2.69	+/-0.030	2.683	✓		Ver	
1.000	+/-0.010	0.999	✓		Ver	
0.300	+/-0.010	0.300	✓		Ver	
0.063 x 45°	+/-0.010	0.063 x 45°	✓		Ver	
Ø1.000	+/-0.010	0.999	✓		Ver	

Measured by: ^{DAS} 52	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 19/03/25	Date: 19/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					